

Date: Monday, 4/23/2007 3:41:46 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LABEL	
Job Number	: 32019		Part Number	: D2851(45)	
Estimate Number	: 10061		Drawing Number	: D2851 REV A1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/23/2007 S.O. No. : N/A		Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/30/2007 Qty: 7 Um: Each	
Previous Run	: N/A				
Written By					
Checked & Approved By					
Comment	: Est. A: 00.04.03 New Issue EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING   <b>Comment: PURCHASING</b> Issue P/O <u>3620</u> <u>C207/04/24</u> (5) Make per Dwg 2851 and QSI 017 (ref.4.1.8.1)
2.0	D2851145P	Placard   <b>Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)</b> Placard
3.0	PACKAGING 1	PACKAGING RESOURCE #1   <b>Comment: PACKAGING RESOURCE #1</b> Receive & Inspect For Transit Damage Ensure material certification is attached  <u>4/20/05/03 (7)</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP   <u>4/20/05/03 (7)</u> <b>Comment: INSPECT WORK TO CURRENT STEP</b>
5.0	PACKAGING 1	PACKAGING RESOURCE #1   <u>4/21/05/08 (7)</u> <b>Comment: PACKAGING RESOURCE #1</b> Identify and Stock Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL

Job Number: 32019

Part Number: D2851145

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

107105108

Job Completion



107105108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PA</i>	APPROVED <i>SA</i>	DRAWING NO. D2851	REV. A SHEET 1 OF 1
DATE 98.11.12		TITLE LABEL	SCALE NTS
A	98.11.12	NEW ISSUE	
A1	<del>03.03.05</del>	ADDED D2851-170	

**RELEASED**  
98.11.18 KE

MAXIMUM DISTRIBUTED LOAD  
XXX lb / YYY kg  
MAY BE SIGNIFICANTLY REDUCED BY LATERAL C OF G

D2851-XXX

XXX = MAX LOAD IN POUNDS

EXAMPLE

<u>PART #</u>	<u>LOAD</u>
D2851-154	154 lb/70 kg
D2851-160	160 lb/73 kg
D2851-220	220 lb/100 kg
<i>A1</i> D2851-170	170 lb/77 Kg

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32019*

MATERIAL: RED LETTERS (0.5" MIN HEIGHT) WITH ADHESIVE BACK



## PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

### Avery Graphics™ A5 Opaque

5-year INTERMEDIATE calendered vinyl film

Dated: 10/3/02

#### Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

#### Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

#### Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)\*\*
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTMD 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss\*: 70 at 60°

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.<sup>2</sup> (91 cm<sup>2</sup>) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

**Typical Converting Methods:**

**CUTTING**

Computer Sign Cutting: yes

Angle of Blade: 30° or 45°

Minimum letter Height: 0.5 inch

**PRINTING**

Thermal Transfer Printing: yes

Ink Jet Printing: no

E-Stat printing: no

Screen Printing: no

**Exceptions:**

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

\*\* Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefor by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damage is caused by Avery Dennison's negligence.

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